

Date: Friday, 02/01/2009 8:31:56 AM.
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH
Job Number	: 44346		
Estimate Number	: 12772		
P.O. Number	:	Part Number	: 41232 200 002 003
This Issue	: 02/01/2009 S.O. No. :	Drawing Number	: 41232-200-002 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 43304	Material	:
Written By	: <u>JLM/09.01.02</u>	Due Date	: 09/01/2009 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-03-05 JLM Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified By:DD		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3R1875	2024 T3 ROUND BAR 1.875



Comment: Qty.: 0.3675 f(s)/Unit Total : 2.9400 f(s)
2024-T3 Round Bar 1.250"
Batch: M11D 063

09/01/08

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
1-TURN AS PER FOLIO FA688 & DWG 41232-200-002 ,
FOLIO REV: N/A
DWG REV: A

2-DEBURR AS REQUIRED

3-Tap 1/4"28NF

4-GRIND RADIUS BY HAND

SA/JP

09/01/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA/JP

09/01/08

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JLM

09/01/06

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 44346

Part Number: 41232 200 002 003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 7957

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

C 209/01/13 (8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

SS 09/01/20 (78)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/20 (28)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST366

SS 09/01/20 (28)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21 JF

Job Completion



le 09.06.21

DART AEROSPACE LTD		Work Order:	44346
Description: Latch		Part Number:	41232-200-002-003
Inspection Dwg: 41232-200-002		Rev: A	Page 1 of 1

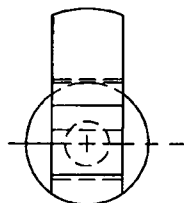
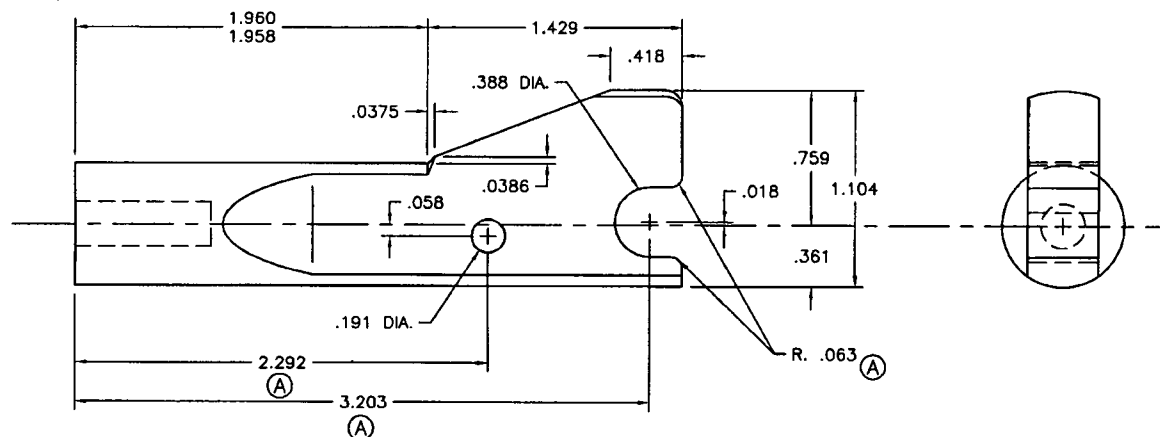
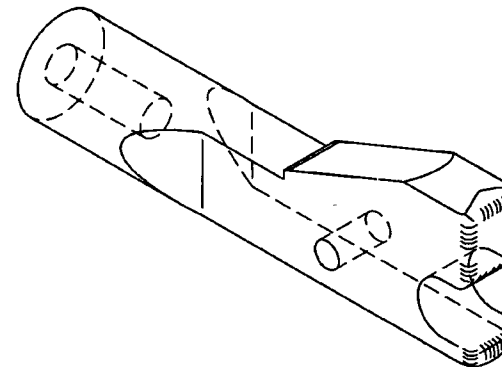
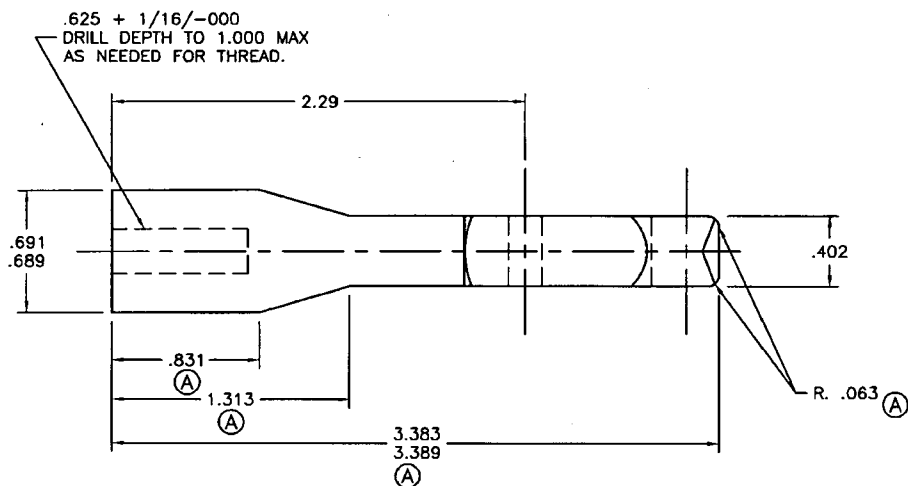
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.29	+/-0.030	2.29				
0.691/0.689	N/A	.690				
0.831	+/-0.010	.830				
1.313	+/-0.010	1.313				
3.383/3.389	N/A	3.388				
0.402	+/-0.010	.404				
R0.063	+/-0.010	R.				
1.960/1.958	N/A	1.960				
1.429	+/-0.010	1.429				
0.375	+/-0.010	/				
Ø0.388	+0.006/-0.001	.390				
0.418	+/-0.010	.420				
0.386	+/-0.010	/				
0.058	+/-0.010	.061				
Ø0.191	+0.005/-0.001	.191				
2.292	+/-0.010	2.292				
3.203	+/-0.010	3.203				
0.018	+/-0.010	.018				
0.759	+/-0.010	.759				
1.104	+/-0.010	1.104				
0.361	+/-0.010	.361				
R0.063	+/-0.010	R.063				
1/4-28 x 1.000	N/A	1/4-28-1.000				

Measured by:	RJ	Audited by:	JL	Prototype Approval:	N/A
Date:	09/01/06	Date:	09/01/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.12	New Issue	KJ/DD	



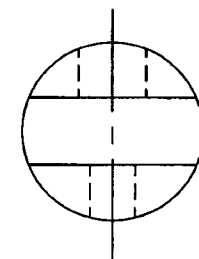
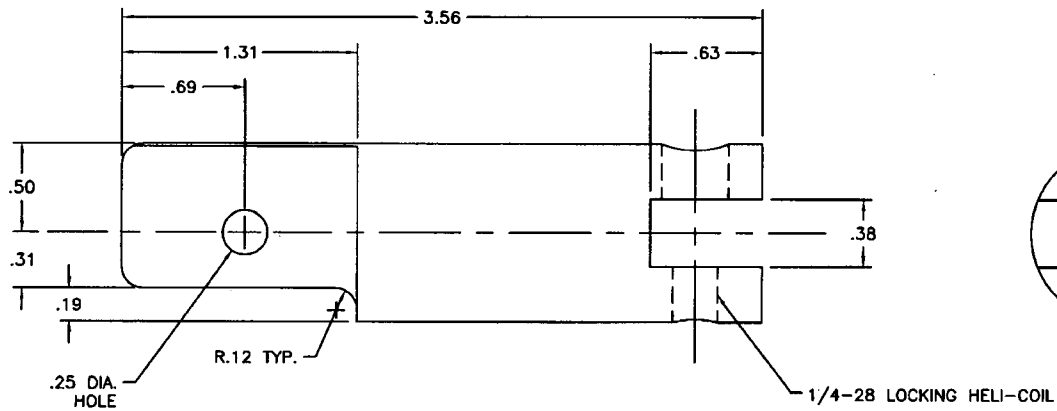
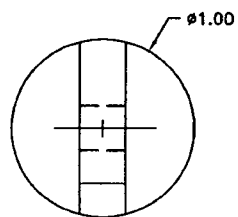
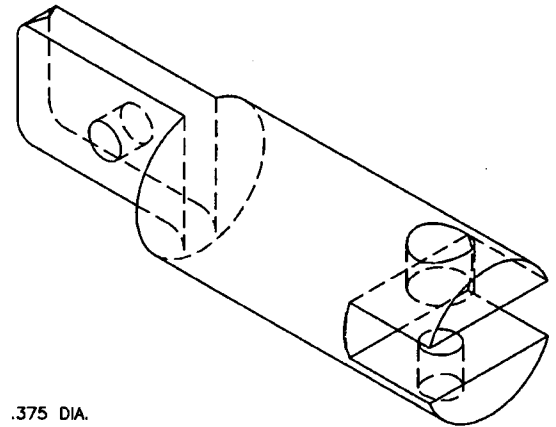
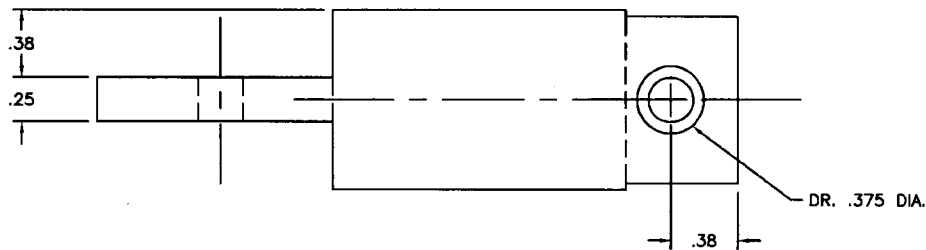
44346

-003 LATCH

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Era Aviation, Inc.

FILE	SIZE	DRG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A



-005 PIVOT ARM

44346

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Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DWG. NO.
41232-200-002
SHT 3 OF 3

REV.
A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

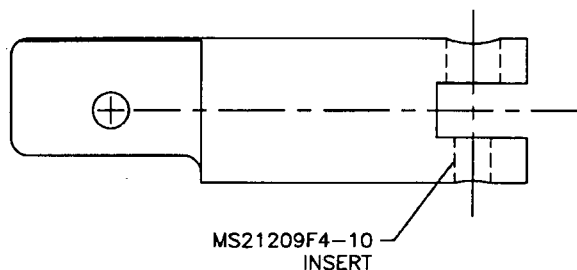
IS

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WAS

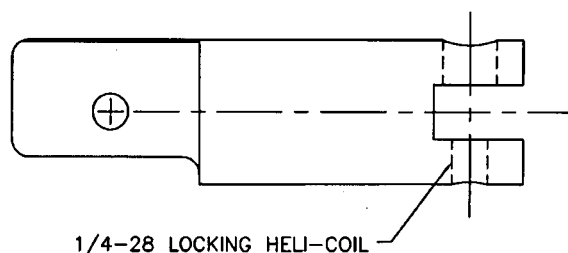
1	MS21209F4-15	INSERT
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

443246

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

TNM ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

PACKING
SLIP

71604

16-Jan-2009

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE:

PURCHASE ORDER/

100623/7957

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	8	8	41232-200-002-003	B44346 ✓

AS
01/01/20

PICKED UP BY / RÉCU: _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

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Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

FACTURE
INVOICE

71604 Rev.00

16-Jan-2009

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE: 100623/7957
PURCHASE ORDER/**CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART-NUMBER DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	8	8	41232-200-002-003 B44346	\$0.00	\$0.00
			MINIMUM CHARGE		\$100.00
			SUB TOTAL:		\$100.00
			TPS/GST:		\$5.00
			TVQ/PST:		\$0.00
			TOTAL AMOUNT DUE:		\$105.00

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : T019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pi ces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

71604

16-Jan-2009

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

NO. DE COMMANDE: 100623/7957
PURCHASE ORDER/



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	8	8	41232-200-002-003 B44346	BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

Soluto

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

